

Work Order ID 62859

Tuesday, October 12, 2010 11:44:15 AM



Page 1

Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid Assembly				Stop	
Start Date:	10/12/2010	Start Qty:	1.00			
Required Date:	10/22/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10-10-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100		0.00							
	Large Fab								
Large Fab									
Large Fab									
	Memo	0.00							
	1- assemble all ribs in DT9446 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9446 jig								
	3- to locate hinges and shims use D2989-041, weld as per dwg D2989								
	A/R ER316 S.S. Rod Batch: <u>M114609</u>								
110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC									
Quality Control	Memo	0.00							

PD 10.10.19

Pl 10.10.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62859

Tuesday, October 12, 2010 11:44:15 AM



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Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

1

10/10/20

125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

10/10/20

①

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Page 4

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Setup Start

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Start Date: 10/12/2010 Start Qty: 1.00

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Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

EP 10/10/21 @

10/10/27

ME

10-10-27

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Picklist Print

Tuesday, October 12, 2010 11:44:19 AM

Page 1

Work Order ID: 62859



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	14.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
				61091				2					
				61424				12					
D2989-3 Rib		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
				59006				1					
				59034				1					
				61393				3					
D2989-4 Rib		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				3					
				61394				3					



PD 10.10.14



PD 10.10.14



PD 10.10.14

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 62859



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2989-5 Manufactured No

100 Each

8.0000

2

2



Rib



PD 10.10.14

Location

Loc Qty

Loc Code

WA

8

61396

4

62367

4

②

D3182-1 Manufactured No

100 Each

12.0000

2

2



Hinge



PD 10.10.14

Location

Loc Qty

Loc Code

WA

12

61395

2

62358

6

62365

4

②

D3442-3 Manufactured No

100 Each

6.0000

2

2



Shim



PD 10.10.14

B62987-5②

Location

Loc Qty

Loc Code

WA

6

61176

4

61756

2

D3827-041 Manufactured No

100 Each

9.0000

1

1



Rib Assembly (Inboard)



PD 10.10.14

Location

Loc Qty

Loc Code

WA

9

61177

3

61758

6

①

Tuesday, October 12, 2010 11:44:19 AM

Shop Packet Print

Page 2

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Picklist Print

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Page 3

Work Order ID: 62859

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3832-5 Manufactured No

100

Each

4.0000

1

1



Mesh (Lid)



PD 10.10.15

Location

Loc Qty

Loc Code

WA

4

60671

1

61759

3

D3833-5 Manufactured No

100

Each

7.0000

2

2



Mesh (Lid End)



PD 10.10.15

B62934 -> 2

Location

Loc Qty

Loc Code

WA

7

53722

1

60673

2

61317

4

D3838-041 Manufactured No

100

Each

3.0000

1

1



Rib Assembly (Basket Lid, LH)



PD 10.10.14

Location

Loc Qty

Loc Code

WA

3

61397

3

D3838-042 Manufactured No

100

Each

1.0000

1

1



Rib Assembly (Basket Lid, RH)



PD 10.10.14

Location

Loc Qty

Loc Code

WA

1

61398

1

*

①

Tuesday, October 12, 2010 11:44:19 AM

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Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/12

SHOP COPY
REVISION
UNCONTROLLED
SUBJECT
WITH
WORK
NO. 62859-
R/010-12

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2989 TITLE BASKET LID ASSEMBLY COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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NOTE: Date & initial all entries

8

7

6

5

4

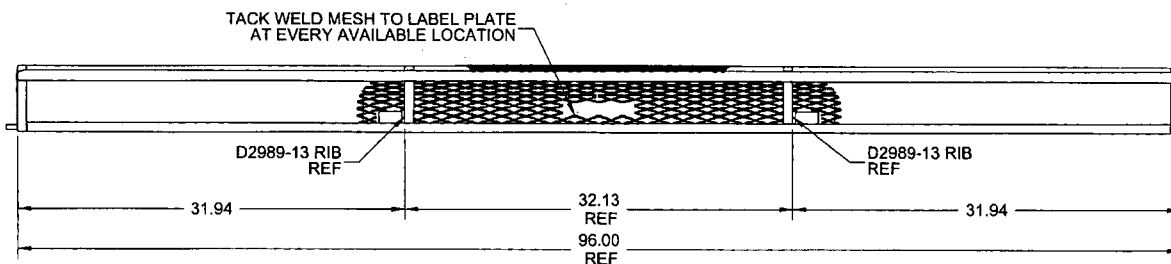
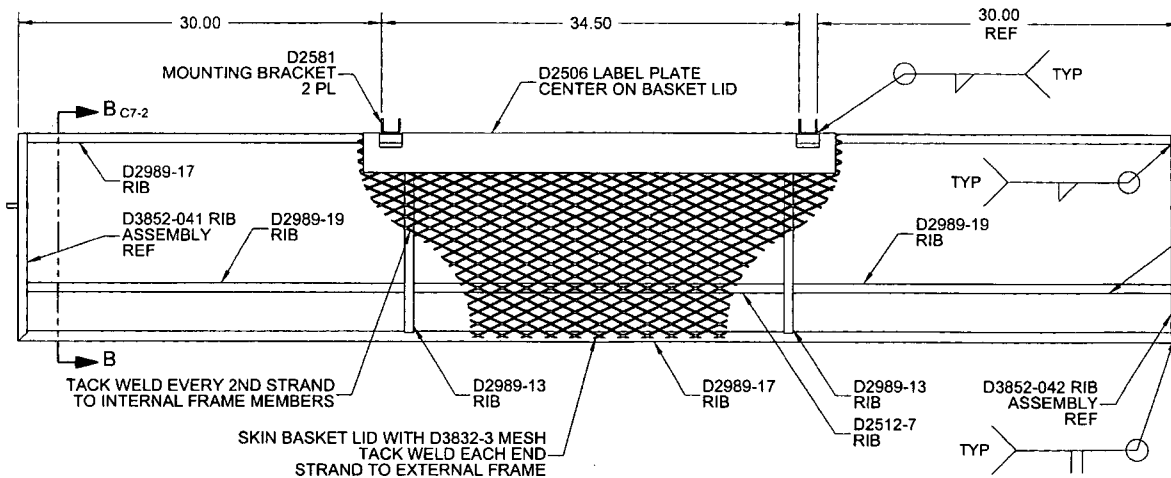
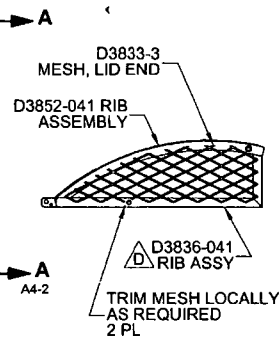
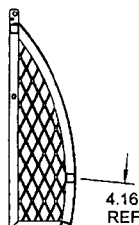
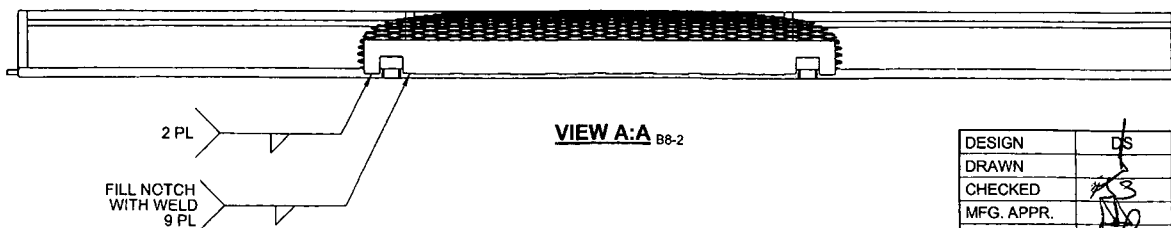
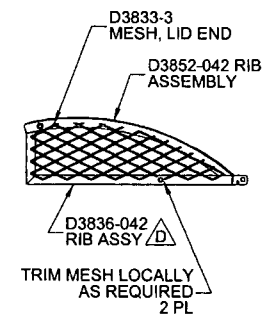
3

2

1

SECTION B-B

D7-2

**D2989-041 BASKET LID ASSEMBLY**
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

u/o 42859

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08/11/18/19

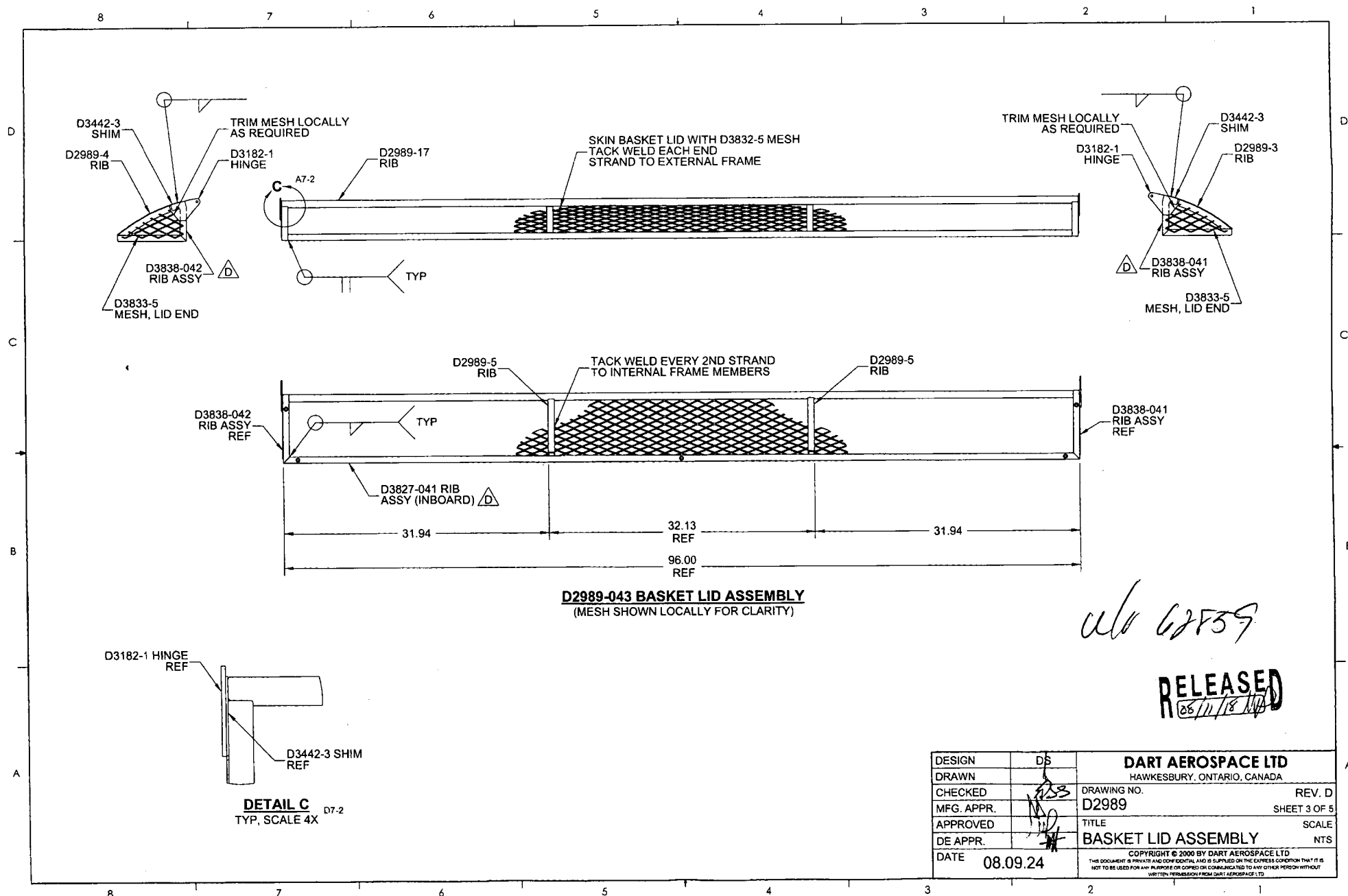
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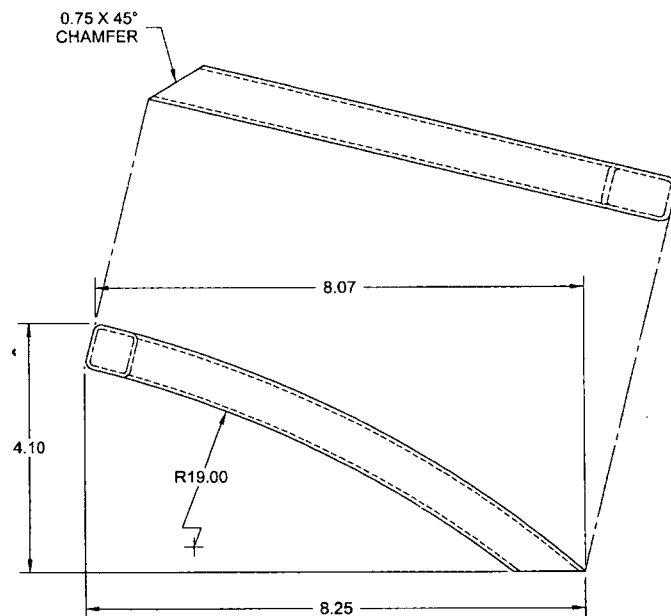
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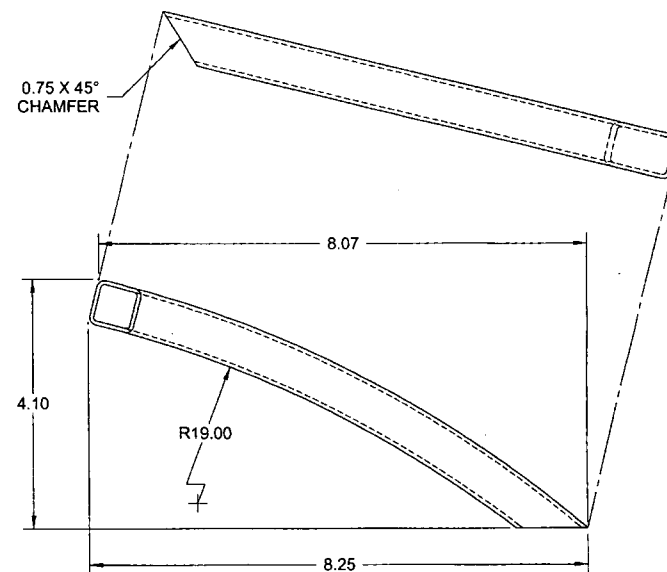
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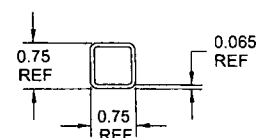
NOTE: Date & initial all entries



D2989-3 RIB



D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
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08/11/18 NW

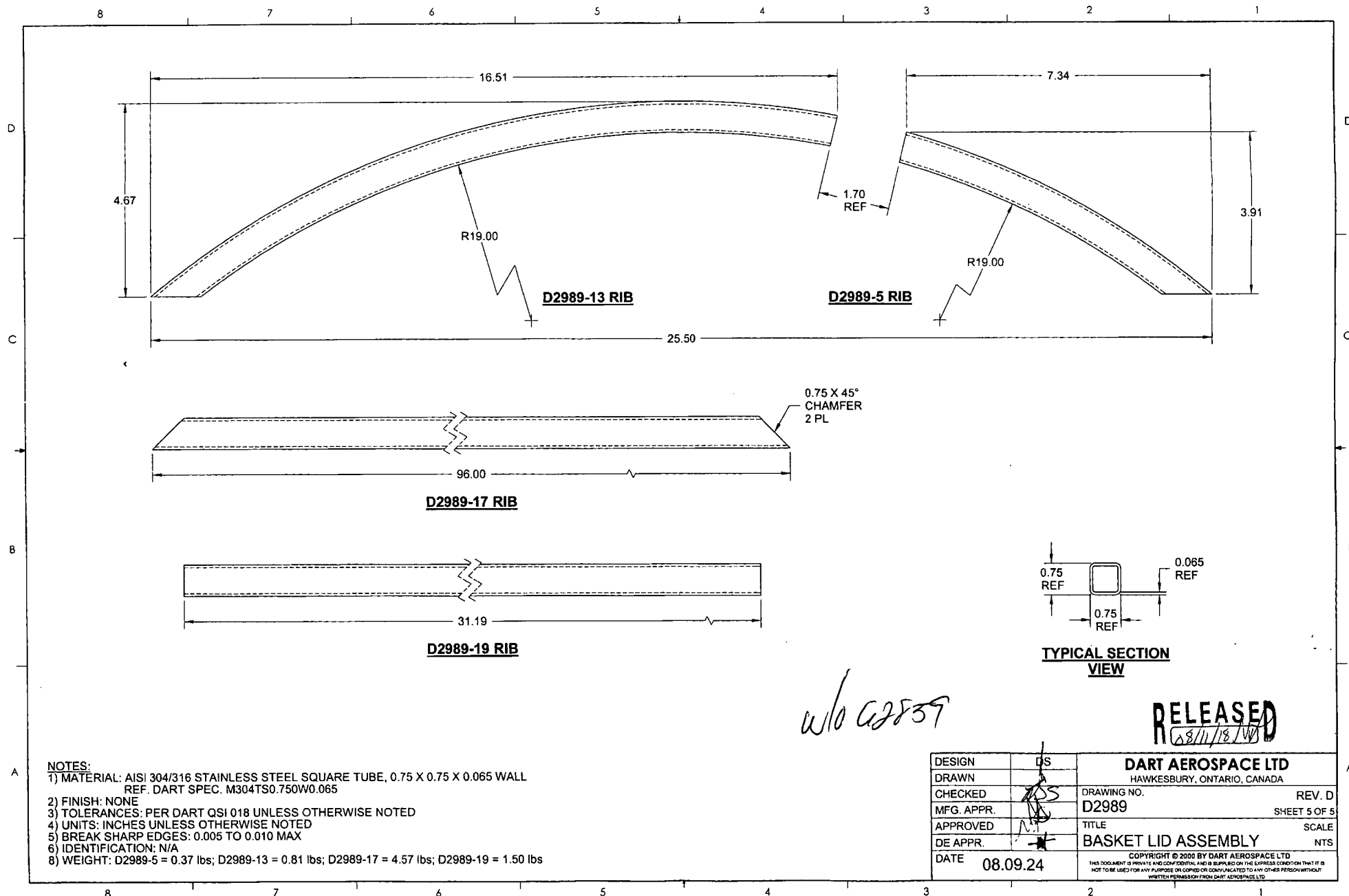
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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
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